

Date: Monday, 02/03/2009 11:23:30 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 46161A	
Estimate Number : 10143	
P.O. Number :	Part Number : D20135
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 45877A01	Material :
Written By :	Due Date : 20/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JD 09.03.02</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 7.2660 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: M110113

SP 09/04/08 (4)

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

- 1-Punch as per template D2013-T5 and Dwg D2013
- 2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545
- 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-5.
- 4-Deburr as required

SP 09/04/08 (4)

M-L 09/04/14 (4X)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SP 09/04/14 (4)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Carl SP 09/04/14 (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:30 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 46161A

Part Number: D20135

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 DJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

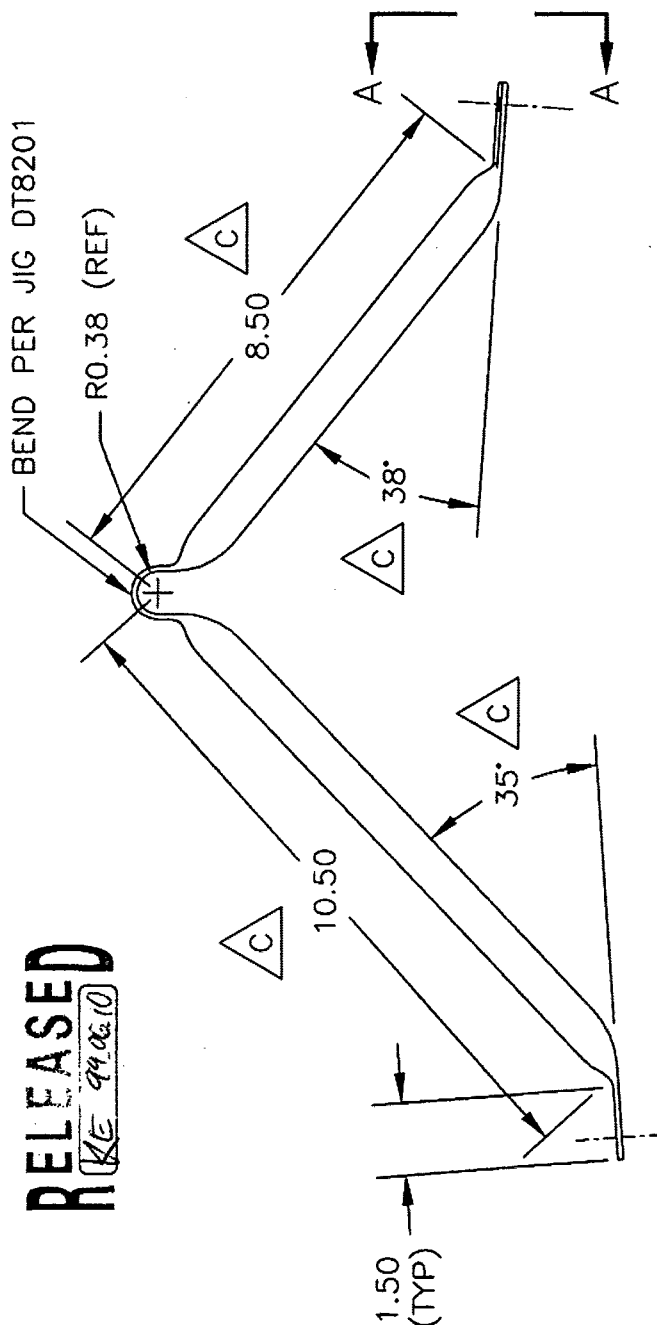
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

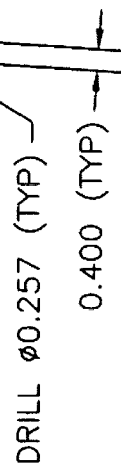
NOTE: Date & initial all entries



DESIGN	JB.	DRAWN BY	RF	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	DS	DRAWING NO.	REV. C
				D2013	SHEET 1 OF 3
DATE	99.06.07			TITLE	SCALE
				MIRROR BRACKET	NTS
A		90.10.22	NEW ISSUE		
B		94.06.15	REDRAWN		
C		99.06.07	REDRAWN, CHANGE OF DIMENSIONS		



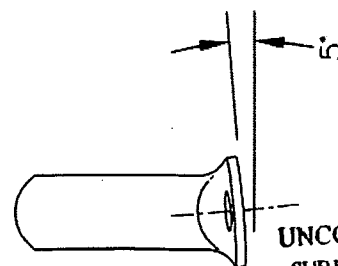
D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

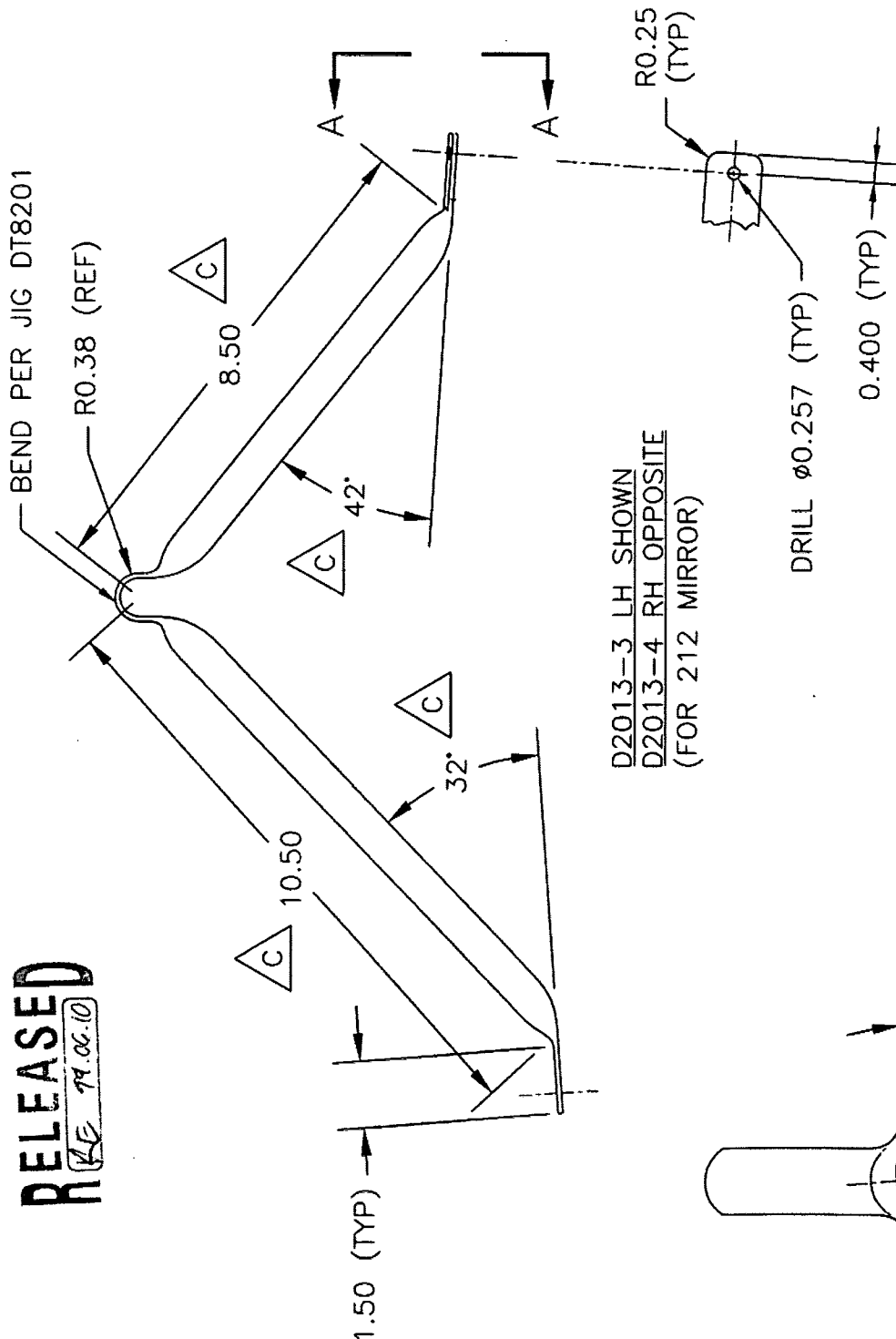
RELEASED
KE 99.06.10



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WORK ORDER
No. 141014

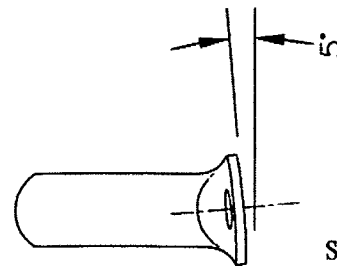


DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED 	DRAWING NO. D2013	REV. C SHEET 2 OF 3
DATE 99.06.07	TITLE MIRROR BRACKET		SCALE NTS



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL



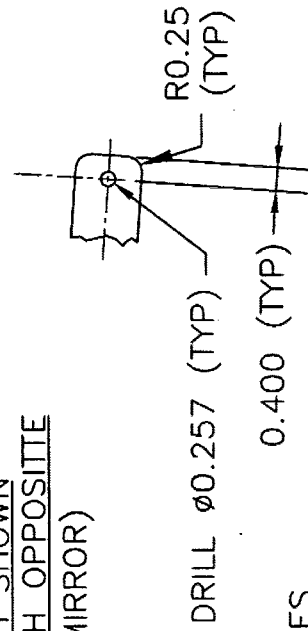
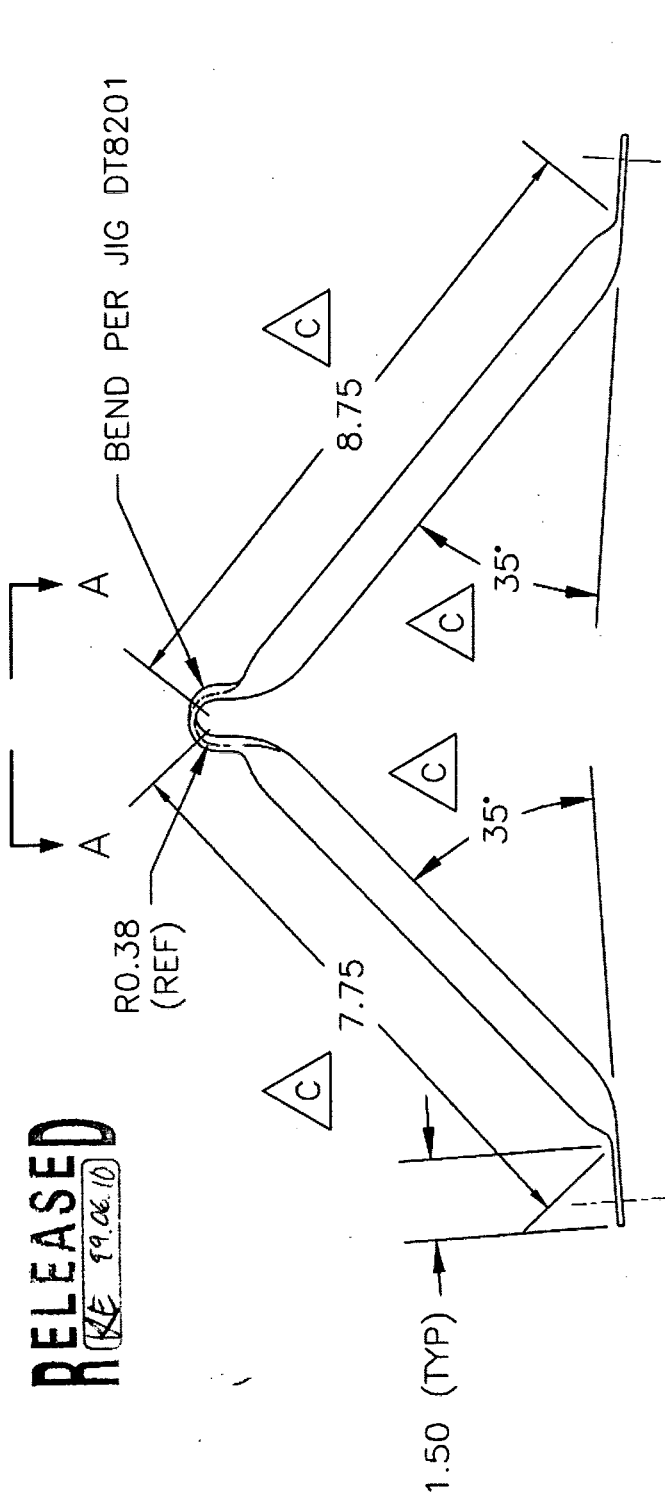
VIEW A-A

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RE 79.06.10



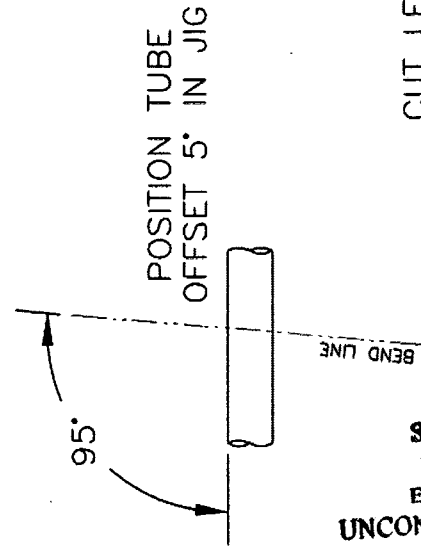
DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED RF	DRAWING NO. D2013	REV. C SHEET 3 OF 3
DATE 99.06.07	TITLE MIRROR BRACKET		SCALE NTS



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)

CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL



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KE 99.06.10

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